

Date: Monday, 08/09/2008 2:51:12 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 41901		
Estimate Number	: 11198		
P.O. Number	:	Part Number	: D3304041
This Issue	: 08/09/2008 S.O. No. :	Drawing Number	: D3304 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40860	Material	:
Written By	:	Due Date	: 19/09/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JUL 08.9.08</u>		
Comment	: Est: C 04.11.17 Step 13 revised KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0875W065	304 round tube .875 x .065w
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Comment: Qty.: 1.4109 f(s)/Unit Total : 8.4653 f(s)
 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall
 (M304TR0.875W.065)
 Identify for D3304-1
 Batch: M109007

J.F. 08/09/21 (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut to length

J.F. 08/09/21 (6)

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
 Cut blank: 15.75" as per Dwg D3304
 Turn as per Dwg D3304
 Identify as D3304-1

J.F. 08/09/21 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/09/21 (6)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 08/09/21 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:51:12 PM
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Drawing Name: TUBE ASSEMBLY

Job Number: 41901

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Drill as per Dwg D3304 using drill Jig D3304-T1

Deburr

FF 08/10/21 (6)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 10/21 (86)

8.0 D33045 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bracket

Pick:

Qty Part Number Description
1 D3304-5 Bracket

Batch

640907

EL 8-10-30 (26)

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004

M107051

EL 8-10-30 (x6)

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08-10-30 (x6) M 08/10/31

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

208-10-31 (6)

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

(6X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
320 OF
3:00

M-L 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:51:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 41901

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 08/11/03

(6)

14.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

PIP PIN

Pick:

Qty	Part Number	Description
1	BLBS-0016	Pip Pin

Batch

109199

FF 08/11/03

(6)

15.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Loop Sleeve

Pick:

Qty	Part Number	Description
2	CBL-460	Loop Sleeve

Batch

109062

FF 08/11/03

(6)

16.0

CBL1240

Cable



Comment: Qty.: 1.0417 f(s)/Unit Total : 6.2502 f(s)

Cable

Pick:

Qty	Part Number	Description
12.5"	CBL-1240	Cable

Batch

1107234

FF 08/11/03

(6)

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

FF 08/11/03

(6)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-10-03 (6)

tx

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: 188

8/11/03

(6x)

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 2:51:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 41901

Part Number: D3304041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/04 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

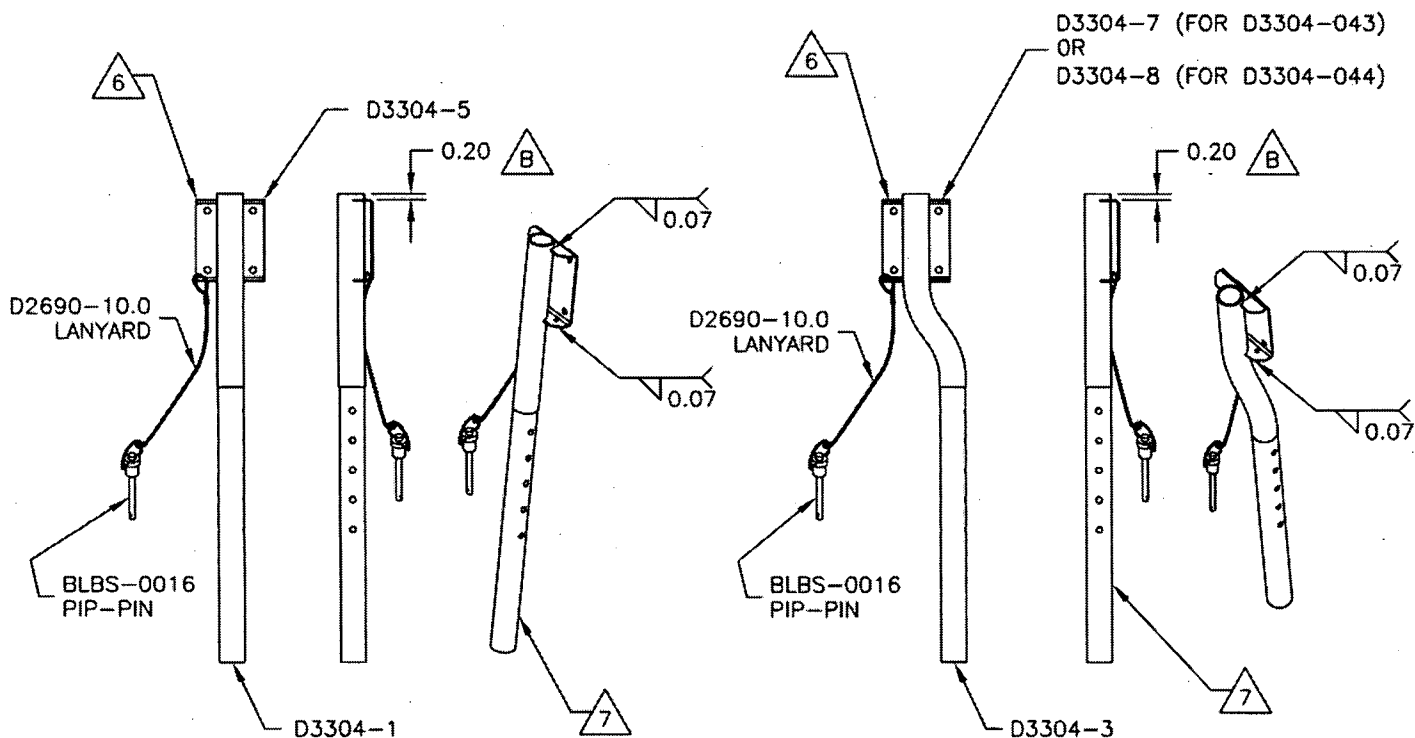
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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RF		RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
		D3304		SHEET 1 OF 4	
DATE		TITLE		SCALE	
05.07.15		TUBE ASSEMBLY		1:6	
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8			



D3304-041 TUBE ASSEMBLY

**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

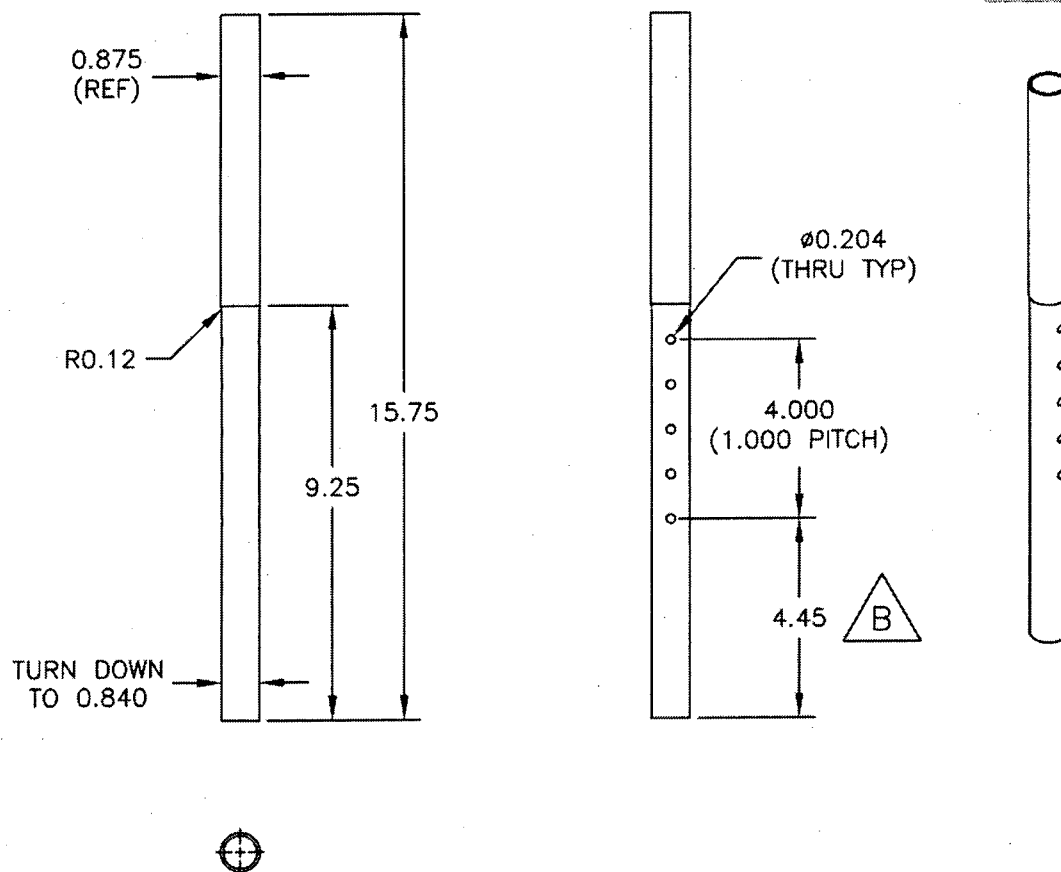
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WITHOUT NOTICE
WORK ORDER
NO. 1



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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

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05-08-11



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

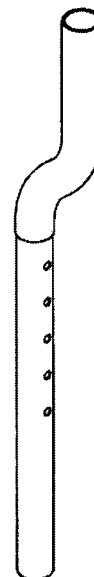
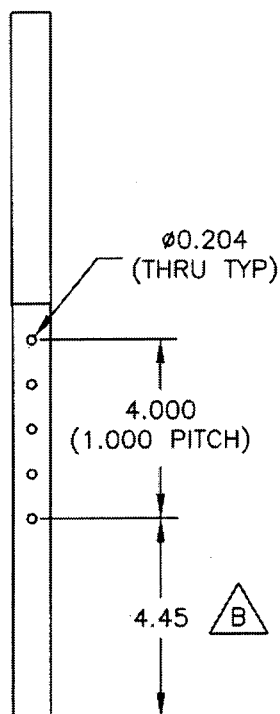
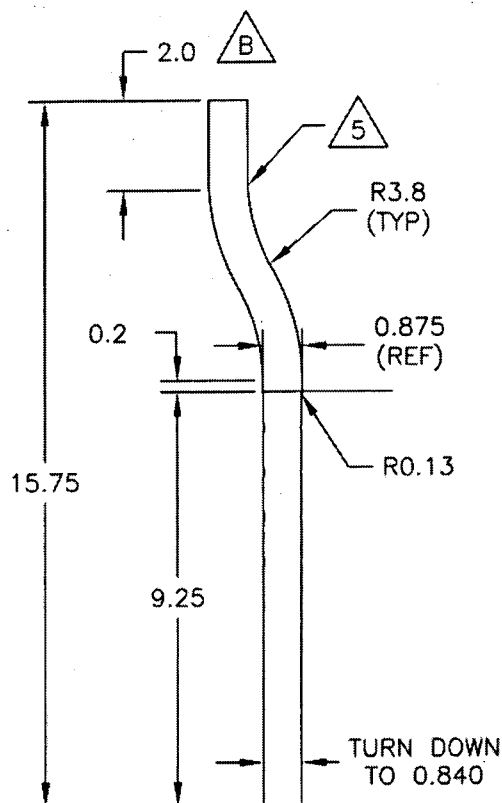
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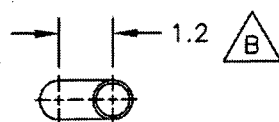
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



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D3304-3 TUBE

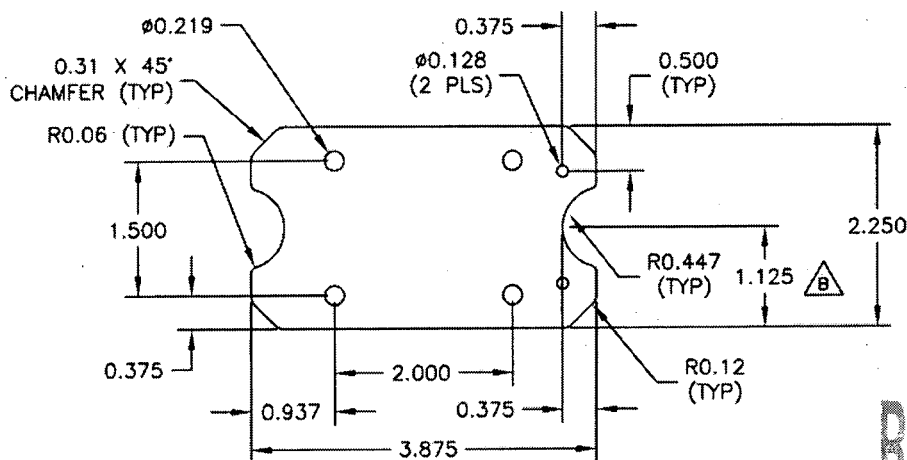
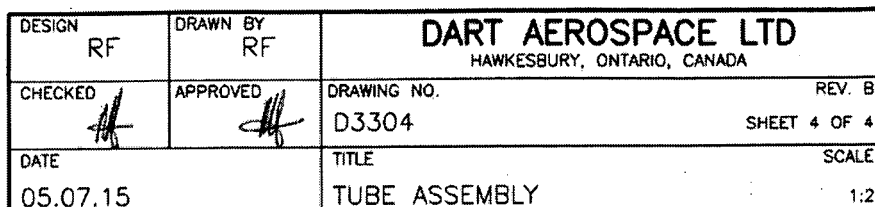
D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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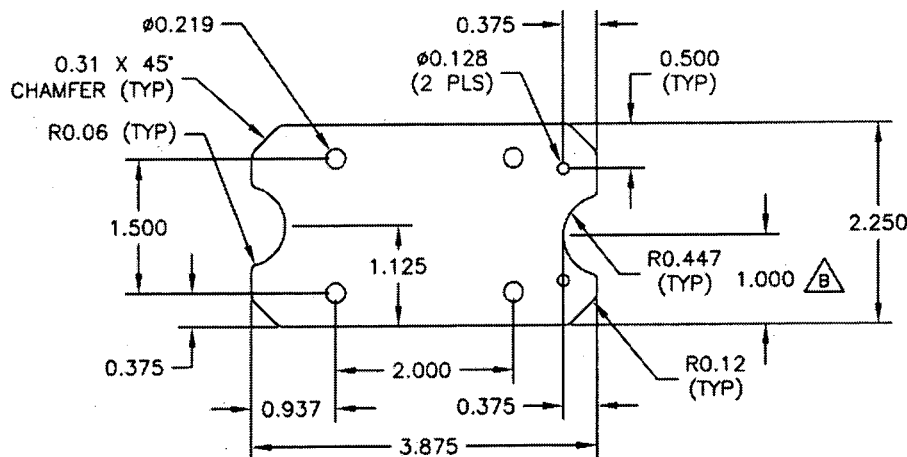
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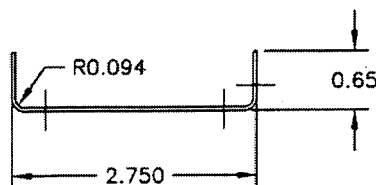


D3304-5 FLAT PATTERN

RELEASE
05-08-11




D3304-7/-8 FLAT PATTERN



D3304-5/-7 BRACKET
D3304-8 OPPOSITE

1. 


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 NO. 41901

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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